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TRANSMISSION PARTS

Instructions

Chrysler 45RFE, 545RFE, 65RFE, 66RFE, 68RFE

TC Limit Valve Kit

TOOL REQUIRED

Part No.
44912-03K

- Valve
- Sleeve
- Spring
- Retainer Plate

NOTE: Kit also serves late model steel valve.

Late Model Steel Valve

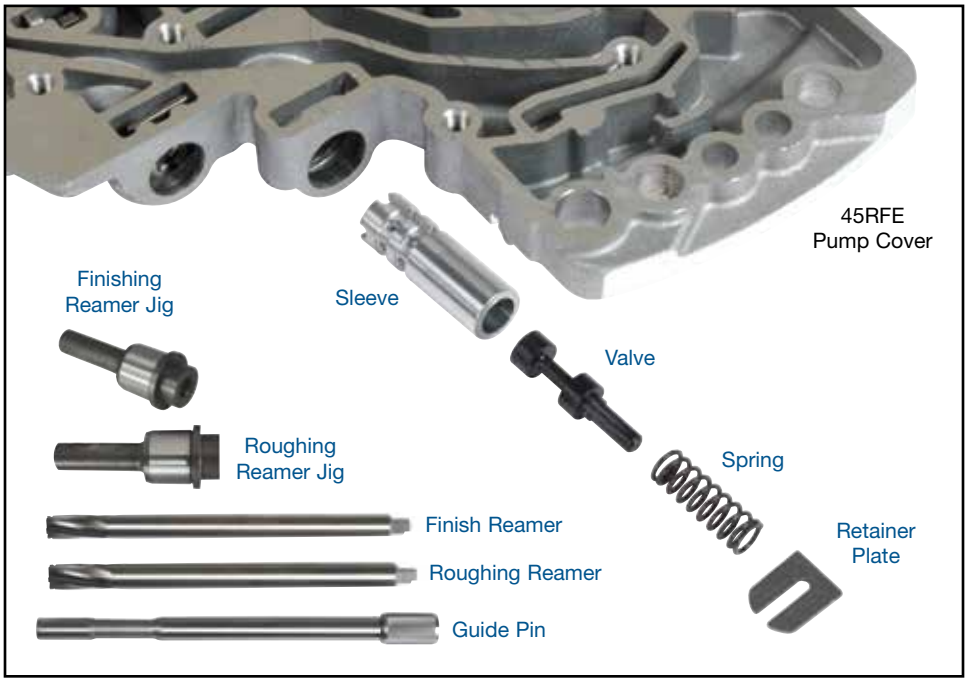
Tool Kit

VALVE BODY FIXTURE REQUIRED

Part No.
F-44912-TL

- Roughing Reamer
- Finishing Reamer
- Reamer Jig (2)
- Guide Pin

NOTE: Sonnax "F-Tool" kits designed to service a specific bore require the VB-FIX, a self-aligning valve body reaming fixture. More information and instructions can be found online at www.sonnax.com.



1. Disassembly

Remove and discard OE retainer, spring and valve.

2. Bore Reaming

To align the TC limit valve bore in the fixture follow the VB-FIX instructions (for reaming instructions/reamer care, please visit www.sonnax.com). Sonnax reaming tool kit **F-44912-TL** and **VB-FIX** are required for this operation.

NOTE

NOTE: From tool kit F-44912-TL, first select jig F-44912-RJ, guide pin F-44912-GP and roughing reamer F-44912-RM. Do not remove pump cover from the VB-FIX. Use low pressure air to remove all debris from the reamed bore. Repeat reaming process with jig F-44912-RJ2 and reamer F-44912-RM2.

3. Installation & Assembly

a. Ensure all debris has been removed from bore and pump body.

b. Insert Sonnax sleeve, slotted end first. Ensure sleeve seats at bottom of bore.

c. Check retaining plate fitment and modify if necessary:

c1. With some castings the sleeve may interfere with Sonnax retainer plate. In these cases, trim the non-slotted end of the sleeve just enough to clear the plate.

c2. Ensure the retainer plate sits below flush of the machined flat surface of pump body. Run straight edge over the area to see if it catches on retainer plate. If necessary, grind a few thousandths of an inch off retainer so it sits just below flush.

d. Insert Sonnax valve and spring into installed sleeve.

e. Compress spring, secure assembly with Sonnax retainer plate.

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